

SHIP: USS GONZALEZ (DDG-66)

ITEM NO: 168-12-001

COAR: 16-512

PCN: EE01-0753

REP FILE NO: 168-04

CMP: NONE

REVISED: 24 OCT 2001

SURVEYOR: DEMERS

1. SCOPE:

1.1 Title: Pallet Truck Stowage/Battery Door; inspect and repair

1.2 Location of Work:

1.2.1 Pallet Truck Stowage/Battery Charging Room (01-205-0-Q)

1.3 Identification:

1.3.1 Quantity (One EA), Cargo Door with Actuator (01-217-1), 48 Inch by 72 Inch (Item No. 0033 of 2.2)

2. REFERENCES:

2.1 Standard Items

2.2 168-6218622 Rev. AA, Structural Door List-Zone 4

2.3 S9169-AQ-MMA-010/95310, Cargo Doors With Actuators, P/N's 56W44-SK-8504-198,-199,-200

3. REQUIREMENTS:

3.1 Accomplish a visual inspection of cargo door listed in 1.3 and located in 1.2 for structural integrity, deterioration, cracks, and areas of wear, damage or distortion.

3.1.1 Cycle door twice (open and close) and check for proper seating, binding or erratic operation.

3.1.2 Submit four legible copies of a report listing the results of the requirements of 3.1 and 3.1.1 to the SUPERVISOR.

3.2 Remove dog assemblies, and disassemble cargo door listed in 1.3 using 2.3 for guidance. Retain parts for assembly.

3.2.1 Clean internal and external parts exposed by removals and disassembly free of oil, grease, dirt, loose paint, and rust.

3.2.2 Accomplish a visual inspection of door, door frame, bulkhead in

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way of door frame, hinge bracket assemblies, actuator, actuator yoke assembly, door mounting bar, door mounting bracket, gasket retainer channel, knife edge, and parts disassembled in 3.2 for wear and defects using 2.3 for guidance.

3.2.2.1 Submit four legible copies of a report listing the results of the requirements of 3.2.2 to the SUPERVISOR.

3.2.3 Provide 15 mandays of labor and 2,000 dollars of material to accomplish repairs to cargo door not previously identified in this Work Item, when directed by the SUPERVISOR. Total cost greater or less than above manday and dollar amounts, when authorized, will be the subject of an equitable adjustment.

3.2.3.1 Submit four legible copies of a weekly report to document labor and material expenditures to the SUPERVISOR.

3.2.4 Remove existing gasket from gasket retainer channel.

3.2.4.1 Accomplish the requirements of 009-32 of 2.1, including Table 2, Line 8, Columns A and B (one coat of Formula 150 conforming to MIL-PRF-24441) for surface preparation and preservation of gasket retainer channel surfaces.

3.2.5 Install new rubber silicone gasket conforming to ZZ-R-765, Grade 30, Class 3B.

3.2.5.1 Trim the ends of the gasket to form a tight butt joint at top center of door and join the gasket ends with adhesive conforming to MMM-A-121.

3.2.5.2 Apply light coat of silicone compound conforming to commercial specification SAE-AS8660 to gasket.

3.3 Assemble dogs, operating handles, and mechanisms retained in 3.2 using new bushings, washers, bearing plates, packing and set screws in accordance with 2.3.

3.3.1 Apply polysulfide sealant conforming to MIL-PRF-81733 to faying surfaces of each bearing plate prior to installation.

3.3.2 Lubricate dogs and operating handles using plastic packing conforming to MIL-P-17578.

3.3.3 Lubricate exposed working parts, using general purpose grease conforming to MIL-PRF-24139.

3.4 Install cargo door removed in 3.2 using new hinge pins, washers, flanged sleeve bearings, cotter pins, hex nuts and grease fittings in accordance with

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2.3.

3.4.1 Lubricate exposed working parts, using general purpose grease conforming to MIL-PRF-24139.

3.4.2 Adjust the dogs, hinges, and wedges for positive dogging action.

3.5 Accomplish an operational test of door actuator on cargo door listed in 1.3 and located in 1.2 in accordance with 2.3.

3.5.1 Submit four legible copies of a report listing the results of the requirements of 3.5 to the SUPERVISOR.

3.5.2 Provide 5 mandays of labor and 1,000 dollars of material to accomplish repairs to actuator not previously identified in this Work Item, when directed by the SUPERVISOR. Total cost greater or less than above manday and dollar amounts, when authorized, will be the subject of an equitable adjustment.

3.5.2.1 Submit four legible copies of a weekly report to document labor and material expenditures to the SUPERVISOR.

(V)(G) "OPERATIONAL TEST"

3.6 Cycle cargo door listed in 1.3 and located in 1.2 twice (open and close) upon completion of repairs and check for proper seating, binding or erratic operation.

3.6.1 Accomplish necessary adjustments and alignment to correct discrepancies resulting from 3.6 in accordance with 2.3.

(V)(G) "DOOR LIMIT ADJUSTMENT"

3.6.2 Adjust actuator stem travel limits in accordance with Paragraph 6-8 of 2.3.

(V)(G) "TORQUE SWITCH ADJUSTMENT"

3.6.3 Accomplish torque switch adjustment on cargo door actuator in accordance with Paragraph 6-9 of 2.3.

(V)(G) "CHALK TEST"

3.7 Accomplish a chalk test on cargo door listed in 1.3. Chalk imprint shall be centered with 100 percent contact.

3.8 Accomplish the requirements of 009-25 of 2.1 for a water hose test on cargo door listed in 1.3. Allowable leakage: None.

3.9 Accomplish the requirements of 009-32 of 2.1 for new and disturbed

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surfaces.

4. NOTES:

4.1 None.

5. GOVERNMENT FURNISHED MATERIAL (GFM):

5.1 LLTM:

1. None

5.2 PUSH MATERIAL:

1. None

5.3 KITTED MATERIAL:

1. None